

Work Order ID 62974

Thursday, October 14, 2010 12:42:25 PM



Page 1

Item ID: D3391-015

Revision ID:

Item Name: Aft Tube Assembly

Start Date: 10/14/2010 Start Qty: 1.00

Required Date: 10/22/2010 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date: 10-10-14

Tooling:

Date:

Setup Start



Stop



Cust Item ID:

Customer:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
----------	--------------	--	--	--	--	--	--	--	--

D3391	Rev H								
-------	-------	--	--	--	--	--	--	--	--

100 0.00

MORI SEIKI CNC LATHE LARGE

Mori Seiki Memo 0.00

Mori Seiki CNC Lathe Large Turn as per Folio FA599 Rev: & Dwg D3391 Rev:

10/11/130

110 0.00

QC2- Inspect parts off machine FAI/FAIB Memo 0.00

QC Memo 0.00

Quality Control Memo 0.00

120 0.00

HAAS CNC VERTICAL MACHINING #1 Memo 0.00

HAAS 1 Memo 0.00

HAAS CNC vertical machine #1 1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: 11/102/14

2-Deburr

11/102/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Reference:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC2- Inspect parts off machine FAI/FAIB

0.00

SL 11/02/14

QC

Quality Control

140



QC8- Inspect parts - second check

0.00

ML 11-2-15

O

QC

Quality Control

150



Skidtubes

0.00

Skidtubes

Memo

0.00

1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

11-2-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



BENDING MACHINE - SKIDTUBES

0.00

CNC Bend 1

CNC Delta 100 Bender

Memo

Form as per Dwg D3391

170



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

180

Operation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(All holes)

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217
Wearplate Jig.

*****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2
previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'bore as per dwg D3391

6-Open up all wearshoe , wearplate to 0.297"and float bag holes to 0.328" as per
Dwg D3391.7- Tranfer holes from D3391-013 for electric step. Open holes as per dwg D3391
section cc-cc

8-Deburr

11-2-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

190



QC

Quality Control

Operation
Description

QCS- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

S 11/02/22

Tool ID

Tool #

Plan

Accept
QtyReject
QtyReject
NumberInsp.
Stamp

200



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

205



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Install crossbolt spacers per dwg D3391 A/R Magnabond 6398 batch: <i>M116227</i> 2- Grind flush	<i>EXP 08/2011</i>							
220	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
225	Pressure Wash per QSI005 4.3	0.00							
HandFinish	Memo	0.00							
Hand Finishing	AND REALODINE AS PER PAR09-043								

M116227
EXP 08/2011

not 11 02 24 (1)

1 d 11 02 24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230



Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M15951

0.00

1 BLN-208

Powder Coating

Memo

0.00

START TIME:

8:00 328°

OVEN TEMPERATURE:

FINISH TIME: 9:20

240



QC

Quality Control

QC3- Inspect Part Finish

0.00

1 6 M 102125

Memo

0.00

250



HandFinish

HandFinishing

0.00

1 6 M 102128

Hand Finishing

Memo

0.00

✓-Install inserts per dwg D3391

✓-Install Aft Cap as per Dwg D3391

✓-A/R Sikaflex-241/-291 M11S114

Sikaflex expiry date: 11/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 62974

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Setup

Start



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Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260



QC5- Inspect part completeness to step on W/O

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

QC

Memo

0.00

11/03/01

Quality Control

270

Identify as per dwg & Stock Location: WLO

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Memo

0.00

1 p 40 u103/01

Packaging

Packaging

280



QC21- Final Inspection - Work Order Release

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Memo

0.00

11/03/01 HJ

Quality Control

PLD-08-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

Thursday, October 14, 2010 12:42:30 PM

Page 1

Work Order ID: 62974



Parent Item: D3391-015



Parent Item Name: Aft Tube Assembly

Start Date: 10/14/2010

Required Date: 10/22/2010

Comments:	IPP rev A	05.12.13	New issue	EC
	IPP rev B	06.02.09	Dwg @ revD	EC
	IPP rev C	07.03.13	dwg @revF	ec
	IPP rev D	07.10.31	ecn 1053P	EC
	IPP Rev:E	ECN 1056	07-11-13	DD verified by: EC
	IPP Rev:F	08-09-10	revH as per dwg	DD verified by:EC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Thursday, October 14, 2010 12:42:30 PM

Work Order ID: 62974



Parent Item: D3391-015



Parent Item Name: Aft Tube Assembly

Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225



Purchased

No

250

Each

4,860.000

12

12



SL 102/28

Insert

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

PK011	4860	
-------	------	--

110768	4860	
--------	------	--

ALS4-428-165



Purchased

No

250

Each

107.0000

4

4



SL 102/28

Inserts

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	7	
----	---	--

6989	7	
------	---	--

ST282	100	
-------	-----	--

114172	100	
--------	-----	--

AN3C4A



Purchased

No

250

Each

1,361.000

6

6



SL 1102/28

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST303	3	
-------	---	--

115438	3	
--------	---	--

ST350	1358	
-------	------	--

114108	14	
--------	----	--

114416	12	
--------	----	--

114523	2	
--------	---	--

115300	330	
--------	-----	--

115589	1000	
--------	------	--

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D3391-015



Parent Item Name: Aft Tube Assembly

Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C5A



Purchased No

250

Each

1,169.000

4

4



11/02/25

Bolt

Location	Loc Qty	Loc Code
----------	---------	----------

ST350	1159	
-------	------	--

114330	11	
--------	----	--

115015	16	
--------	----	--

115371	100	
--------	-----	--

115422	100	
--------	-----	--

115594	432	
--------	-----	--

<u>115835</u>	500	
---------------	-----	--

ST351	10	
-------	----	--

113121	10	
--------	----	--

D2646



Manufactured No

250

Each

41.0000

1

1



11/02/25

Aft Cap

Location	Loc Qty	Loc Code
----------	---------	----------

FP-4	36	
------	----	--

<u>57332</u>	36	
--------------	----	--

fp5	1	
-----	---	--

61752	1	
-------	---	--

FP6	4	
-----	---	--

52663	4	
-------	---	--

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Aft Tube Assembly

Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3537-1



Manufactured No

250

Each

14.0000

1

1



10/21/28

Wearpad

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	FP	1	B65057
	55465	1	
	FP017	6	
	61986	6	
	FP17	7	
	57713	3	
	60491	3	
	61640	1	

D3537-7



Manufactured No

250

Each

15.0000

1

1



10/21/27

Wearpad

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	FP	5	
	46346	5	
	FP16	10	
	56831	10	

D3553-1



Manufactured No

250

Each

41.0000

1

1



10/21/28

Gasket

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	FP	41	
	33868	1	
	56568	40	X1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Aft Tube Assembly

Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3553-3



Manufactured No

250

Each

45.0000

1

1



all 11/02/25

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	45	
----	----	--

53480

	45	
--	----	--

D3670-4-200



Manufactured No

250

Each

64.0000

14

14



X1

SPACER

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

LG	64	
----	----	--

57349

	64	
--	----	--

D3672-1



Manufactured No

250

Each

855.0000

2

2



Phenolic Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST077	855	
-------	-----	--

42329

	150	
--	-----	--

52505

	705	
--	-----	--

X5

2

all 11/02/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order: 62924

Description: Float Skidtube (412)

Part Number: D3391-3

Inspection Dwg: D3391 Rev: H

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.00	/		lafe	SD /
3.500	+/-0.010	3.594	/		Verl	SD -5
88.93	+/-0.030	88.93	/		lafe	SD -1
44.995	+/-0.030					
Ø3.200	+/-0.010	3.208	/		Verl	SD -5
88.93	+/-0.030					
Ø3.750	+/-0.010	3.748	/		Verl	SD -5
30° x 160" chamfer	+/-0.010	30° x 150	/		Verl	SD -5

Measured by: JL

Date: 10/11/10

Audited by:

Date:

HAAS Section						
1.526	+0.000/-0.030	1.508	/		Vern CNC-02	
7.500	+/-0.010	7.499	/		"	
27.750	+/-0.010	27.750	/		m-tape	
31.750	+/-0.010	31.750	/		"	
35.250	+/-0.010	35.250	/		"	
3.300	+/-0.010	3.299	/		Vern CNC-02	
0.200	+/-0.010	.200	/		"	
3.520	+/-0.010	3.516	/		MIC 1LM4	
0.687	+0.010/-0.000	-0.693	/		Vern CNC-02	
R0.062	+/-0.010	.062	/		RG	
Ø0.484	+0.005/-0.001	.487	/		Vern CNC-02	

Measured by: JL

Date: 11/02/11

Audited by: ML

Date: 11-21-11

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	SKY AD

2000

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UNCONT.

SUBJECT TO APPROVAL

W.I.T. & T.N.C. APPROVED

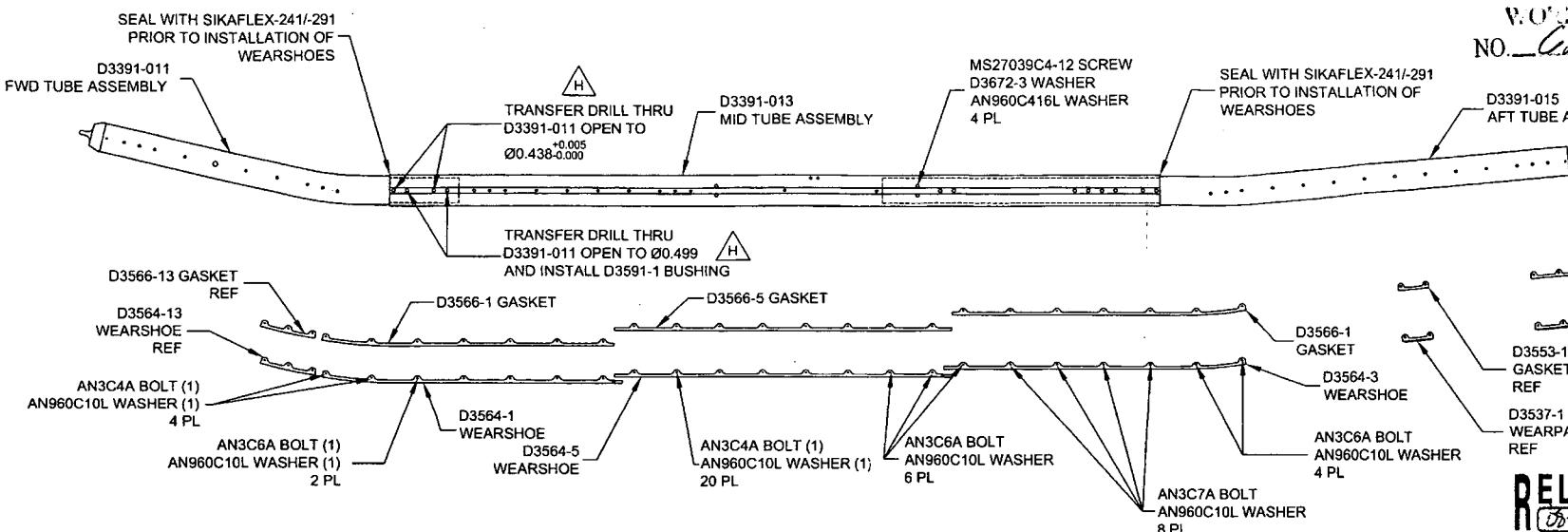
WORK APPROVED

NO. 22979
B20104

D3553-3
GASKET
REF
D3537-7
WEARPAD
REF

D3553-1
GASKET
REF
D3537-1
WEARPAD
REF

DEO ATTACHED

RELEASED
05-04-05 AWD3391-041 ASSEMBLYD3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
1	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	GASKET
4	D3872-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS2703C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. CBORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DS1 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS. DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	A/S	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN ON CALL OR ON REQUESTED BY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

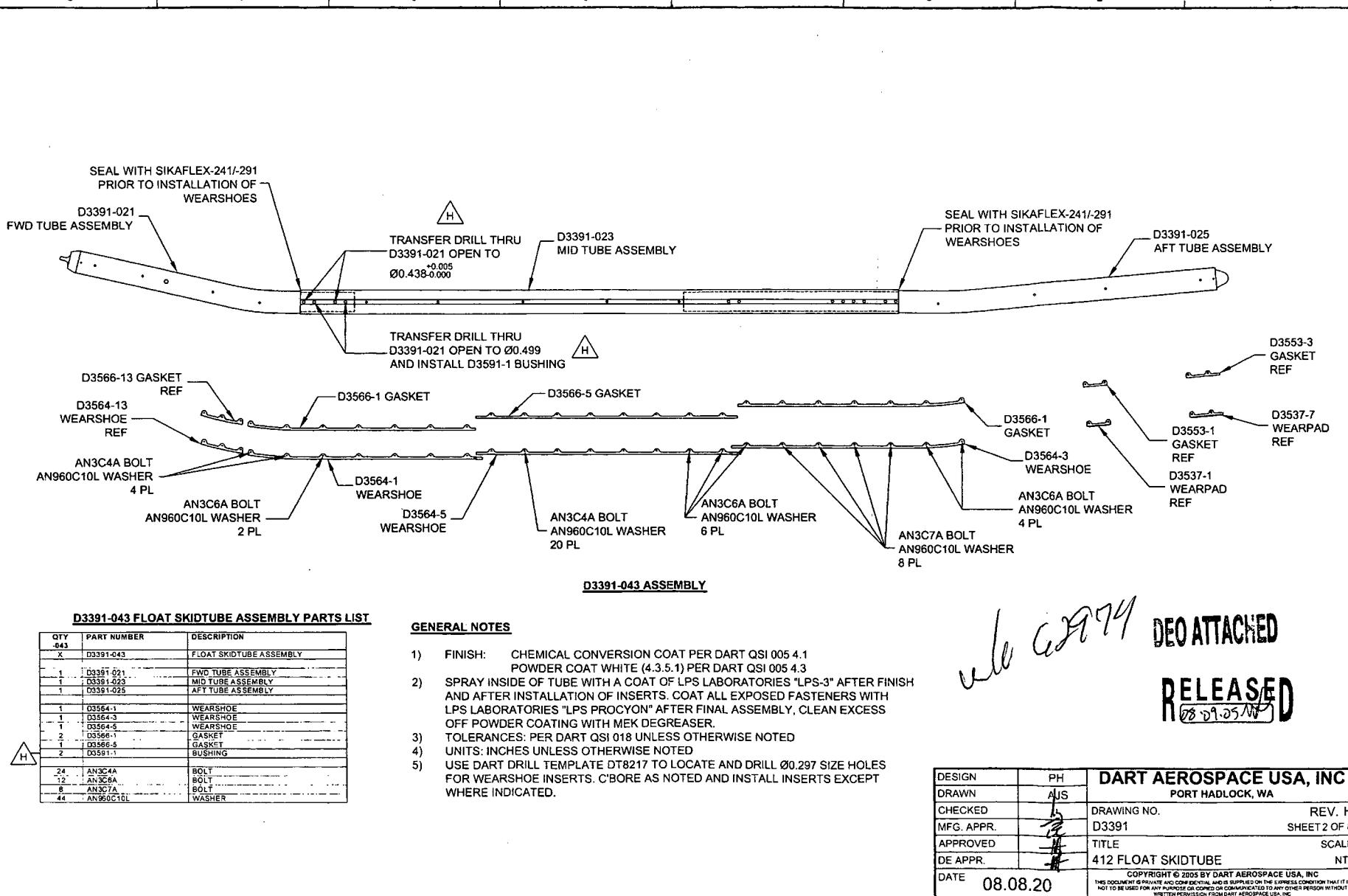
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



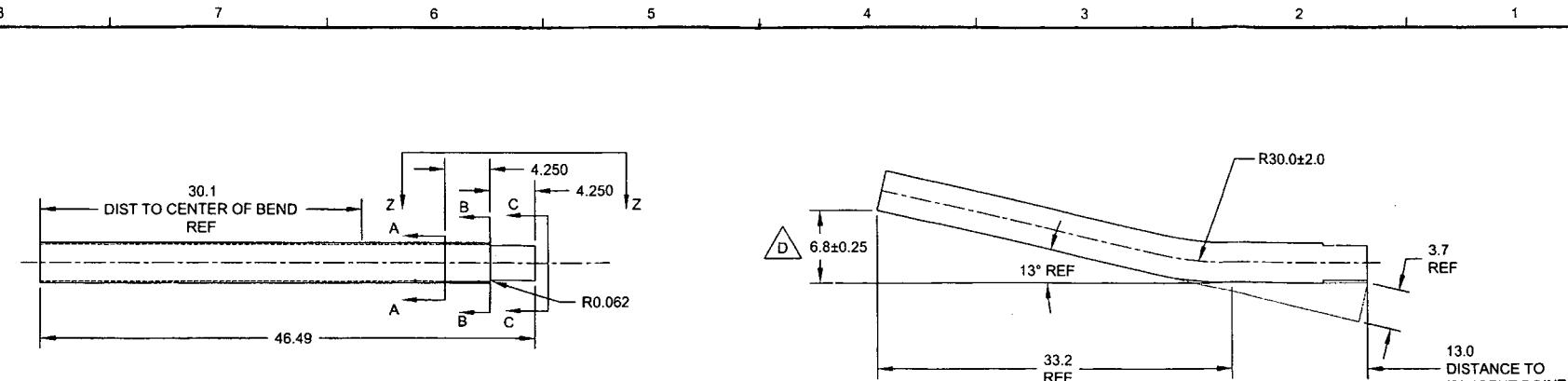
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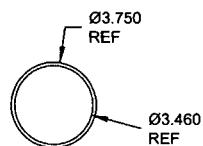
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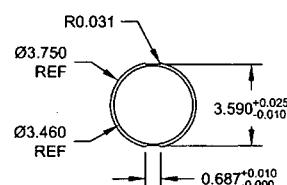


D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)

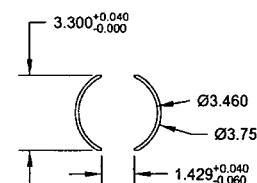
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



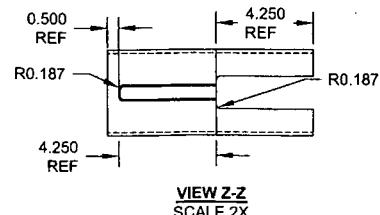
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



DESIGN DRAWN	PH AUS	DART AEROSPACE USA, INC PORT HADLOCK, WA
CHECKED		DRAWING NO. D3391
MFG. APPR.		REV. H SHEET 3 OF 8
APPROVED	JAN	TITLE 412 FLOAT SKIDTUBE
DE APPR.	✓	SCALE NTS
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08.08.20

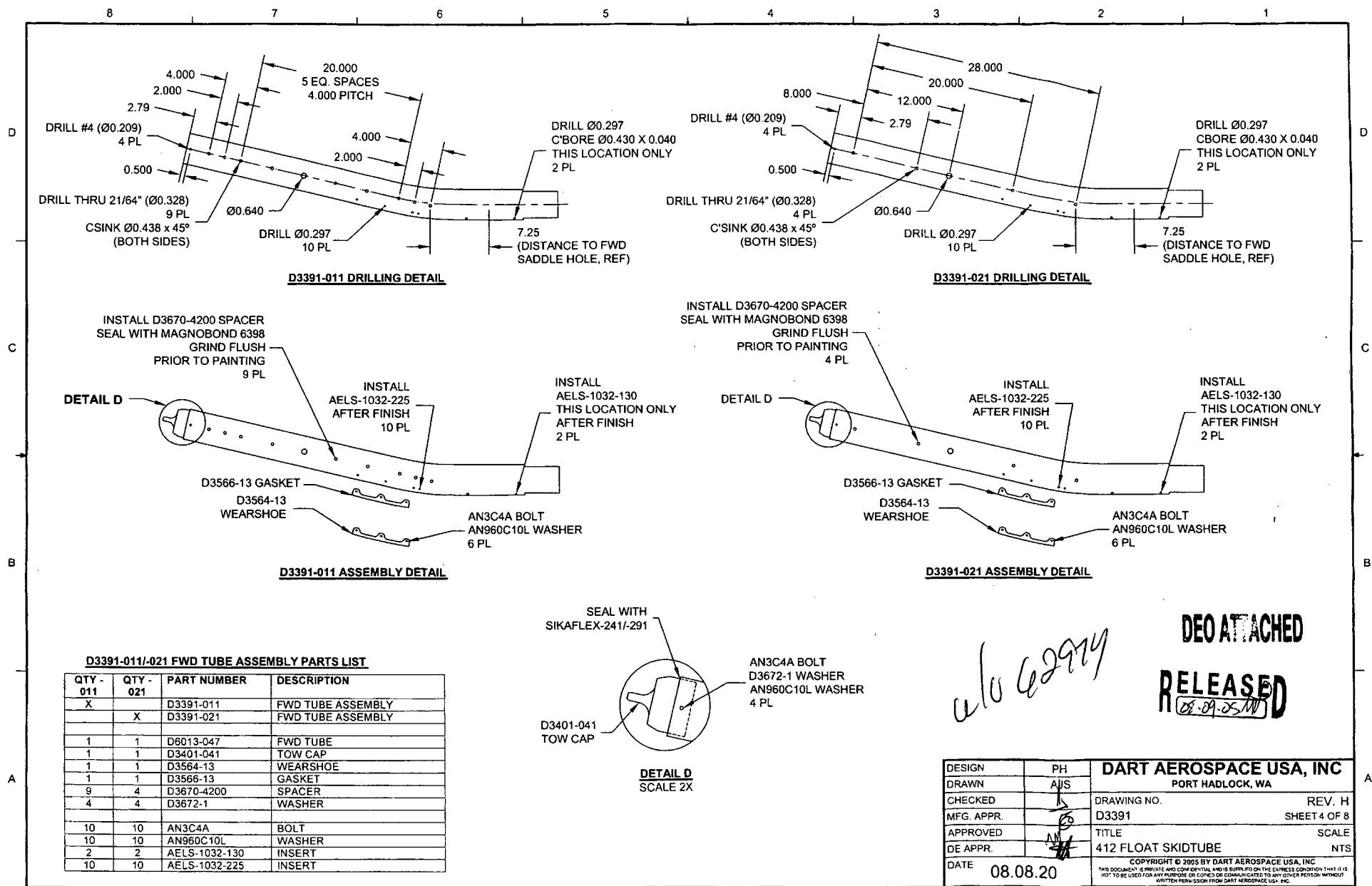
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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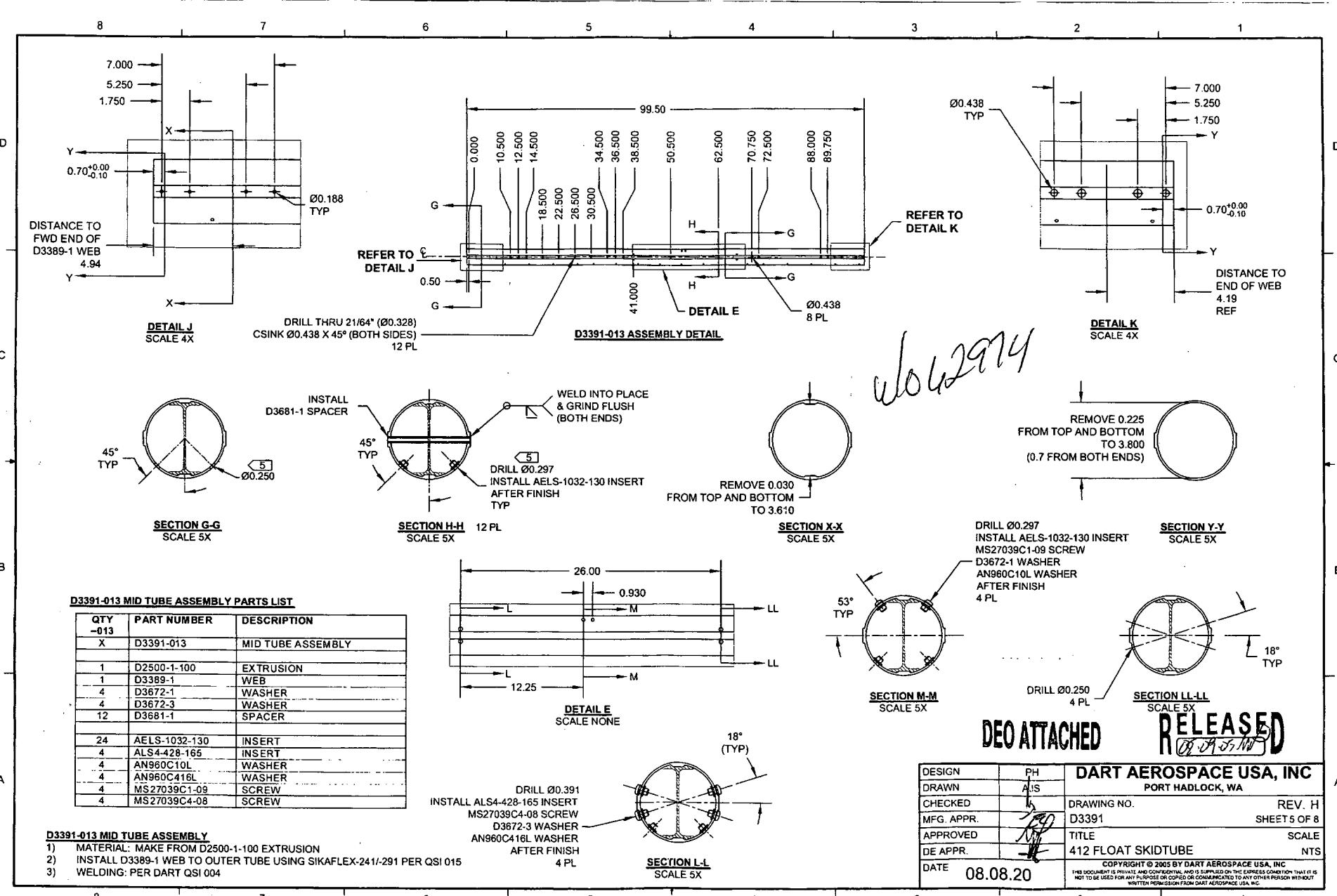
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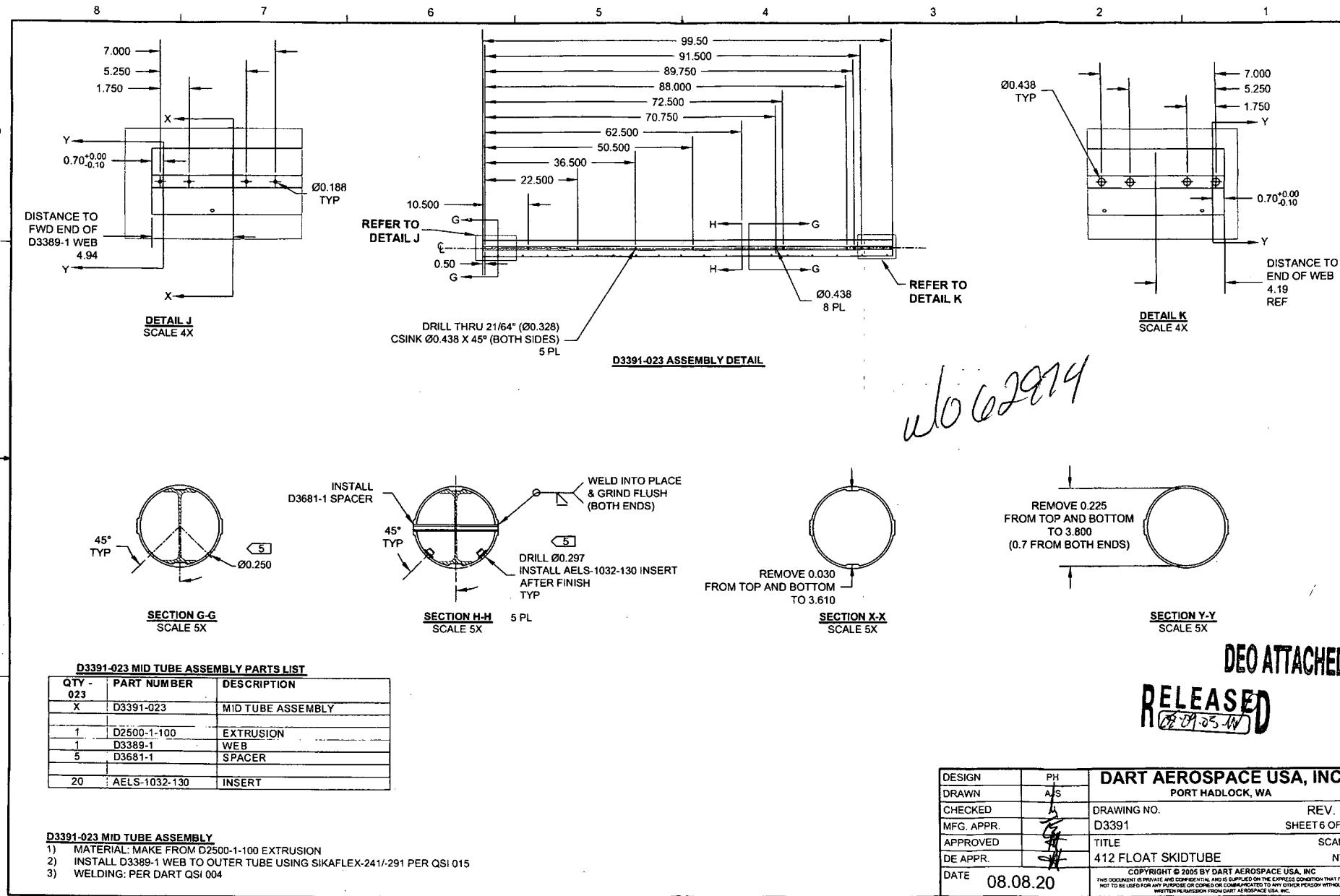
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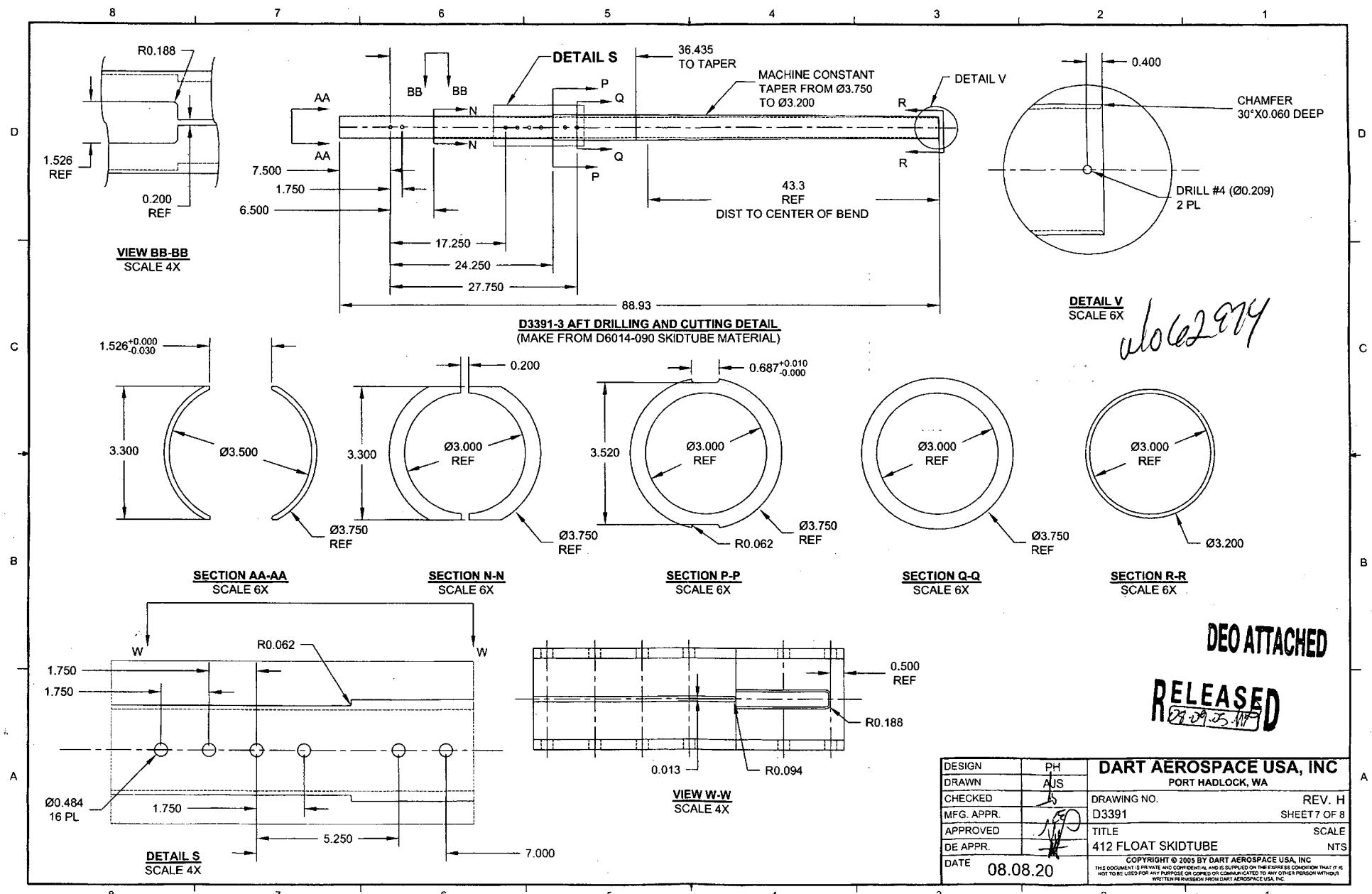
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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RELEASED
28-09-05

DESIGN	PH	DART AEROSPACE USA, INC		
DRAWN	AJS	PORT HADLOCK, WA		
CHECKED	<u>15</u>	DRAWING NO.	REV. H	
MFG. APPR.		D3391	SHEET 7 OF 8	
APPROVED	<u>MM</u>	TITLE	SCALE	
DE APPR.	<u>MM</u>	412 FLOAT SKIDTUBE	NTS	
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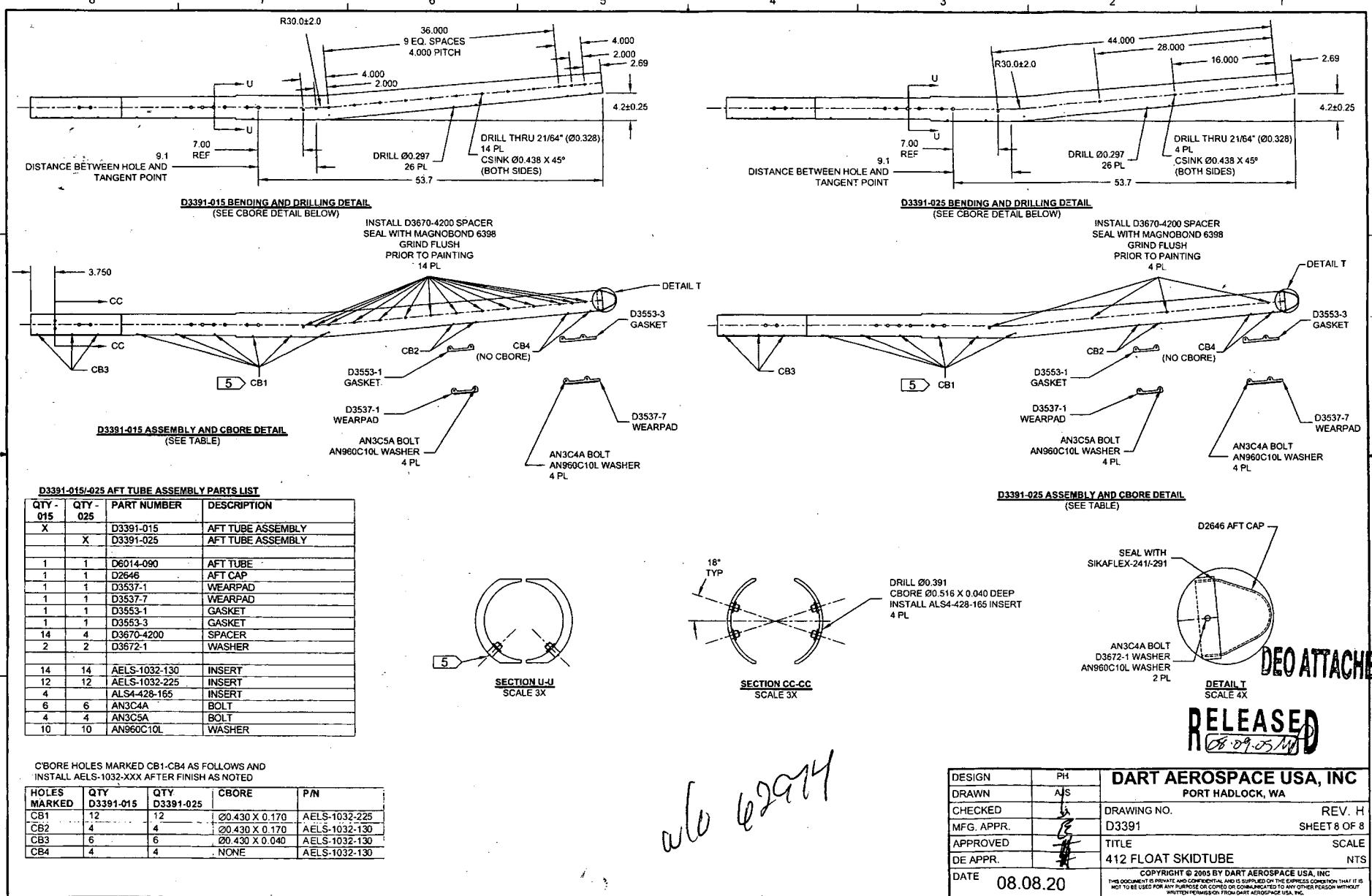
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>(P)</i>	CHECKED <i>1</i>	DATE 09.09.23	MFG. APPR. <i>AA</i>	DATE 09/09/25	APPROVED <i>MP</i>	DE APPR. <i>HP</i>	DATE 09/09/30

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
2010-02-02
MP

u/u 6/29/11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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